

Work Order ID 109064

\*109064\*

Page 1

November-08-13 2:22:50 PM

Item ID: D3262-043

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Canister Assembly

Start Date: 11/08/13 Start Qty: 3.00

\*3\*

Cust Item ID:

Required Date: 11/15/13 Req'd Qty: 3.00

\*3\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3262

E

100

Weld per dwg A/R Aluminum rod Batch: 11271165 0.00

\*100\*

Large Fab

Memo

0.00

Large Fab

Weld canister assembly as per Dwg D3262 using DT8739 to align fittings

3 13-11-11 11

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

\*110\*

QC

Memo

0.00

Quality Control

3 13-11-13

120

QC5- Inspect part completeness to step on W/O 0.00

\*120\*

QC

Memo

0.00

Quality Control

Pressure test as per Dwg D3262

3 13-11-13

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\*109064\*

Page 2

Item ID: D3262-043

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\*N900040100\*

Setup Start \*NS1\*

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Stop \*NS2\*

Item Name: Canister Assembly

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\*3\*

Cust Item ID:

Required Date: 11/15/13 Req'd Qty: 3.00

\*3\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
*130*									
HandFinish	Memo	0.00							
Hand Finishing									
140	White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum	0.00							
*140*									
Powdercoat	Memo	0.00							
Powder Coating	****Ensure to mask the ends **** START TIME: 7:40 OVEN TEMPERATURE: 320° FINISH TIME: 8:10								
150	QC3- Inspect Part Finish	0.00							
*150*									
QC	Memo	0.00							
Quality Control									

DAS  
34  
9-88

13-11-19

DQA:

Date: 13/12/05



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 13/11/22

Work Order update only ☐

Work Order: <u>109064</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D3262-043</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-3255</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input checked="" type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator	X	13/11/14	30	Qty +1 CANISTER. WAS DROPPED after ACID etching.	S	Due to other issues + Fear of Failure in Rebuild.	CF 13-11-14	SAD 13/11/14	
Offset/Setup				Re miss handling of parts	Q32042 13/11/14	Part scrap/Destroy. No Rebuild.	S 13/11/14		S 13/11/14 Q32042
Process									
Supplier									
Training									
Transport									
Unapproved									


## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input checked="" type="checkbox"/> Other <u>misshandling of parts / part slipped out of employees hands.</u>	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled
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Page 3

## Quality Control

13/11/21 

ME  
13-11-20

# Picklist Print

November-08-13 2:22:50 PM

Page 1

Work Order ID: 109064  
Parent Item: D3262-043  
Parent Item Name: Canister Assembly

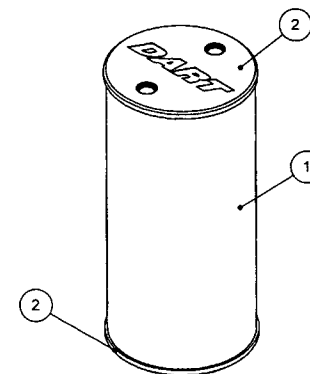
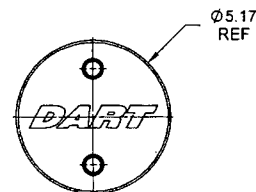
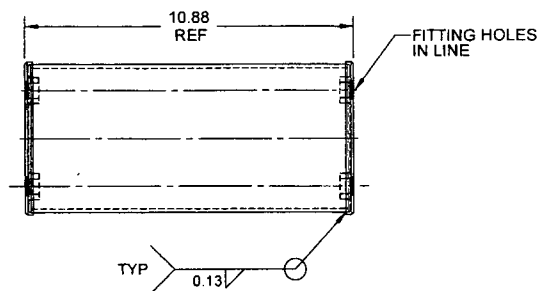
Start Date: 11/08/13  
Start Qty: 3.00

Required Date: 11/15/13  
Required Qty: 3.00

Comments: IPP rev A 10.01.19 new issue EC verified by: DD  
10.05.10 verified :EC  
IPP Rev:B as per ECN10-571 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3262-1 Tube		Manufactured	No			100	Each	6.0000	1	3	(3)	13.11.11	PD
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002		6							
				106183		6			3				
D3262-5 Cap		Manufactured	No			100	Each	13.0000	2	6	(6)	13.11.11	PD
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002		1							
				74724		1							
				WA003		12							
				106038		6			5				
				107978		4			1				
				95353		2							

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP



# D3262-041 CANISTER ASSEMBLY

RELEASED  
2010-05-07

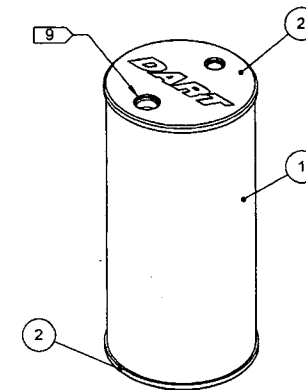
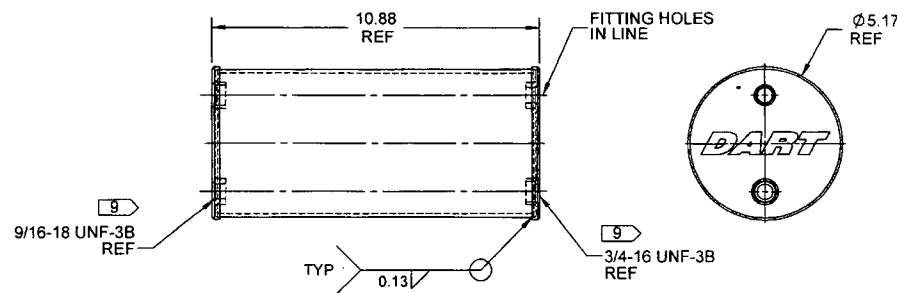
## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.51 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR  
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

*no wordy*

E	0.25 WAS 0.45 (ZNC7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7-5); ADD DIMENSION (ZN B1-4, D1-5, B1-5)	RF	10.05.03
D	ADD D3262-043/-5 (ZN B5-2; B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4; C2-4) PER CAR 09-004	RF	09.12.30
C	Ø5.165 WAS Ø5.190	RF	06.08.31
B	ADD PRESSURE TESTING OPTION	MB	05.02.14
A	NEW ISSUE	RF	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3262	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FUEL PURGE CANISTER	NTS
DATE	10.05.03	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
	X	D3262-043	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-5	CAP



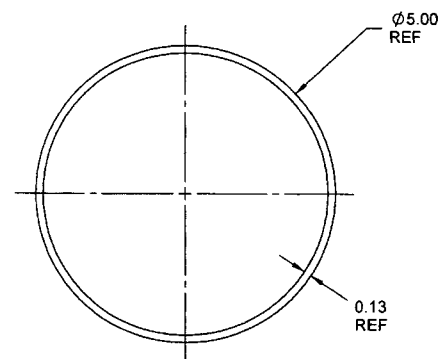
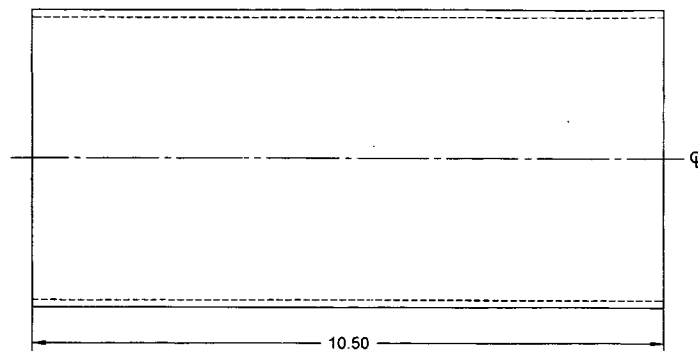
**D3262-043 CANISTER ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.50 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR  
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

**RELEASED**  
2010-05-07

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3262</b>	REV. E
MFG. APPR.	<i>[Signature]</i>	TITLE <b>FUEL PURGE CANISTER</b>	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	SCALE	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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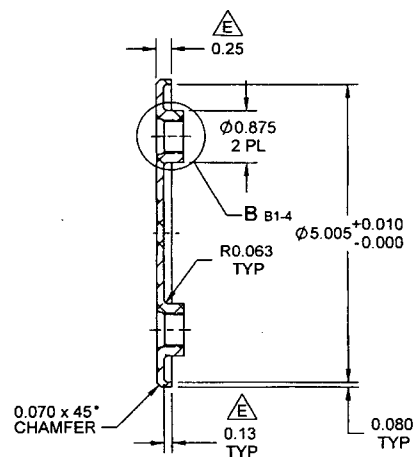
**D3262-1 TUBE**

**NOTES:**

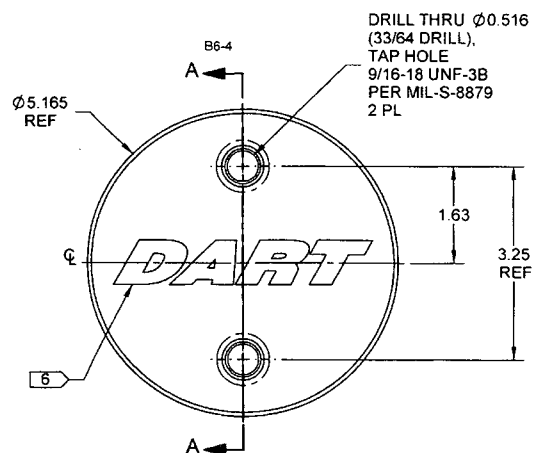
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T6T5.000W.125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.96 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

**RELEASED**  
2010-05-07  
MM

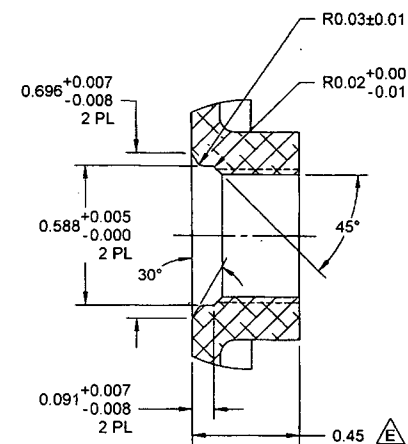
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. <b>D3262</b>	REV. E
MFG. APPR.	RF	SHEET 3 OF 5	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>FUEL PURGE CANISTER</b>	NTS
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**SECTION A-A** C5-4



**D3262-3 CAP**



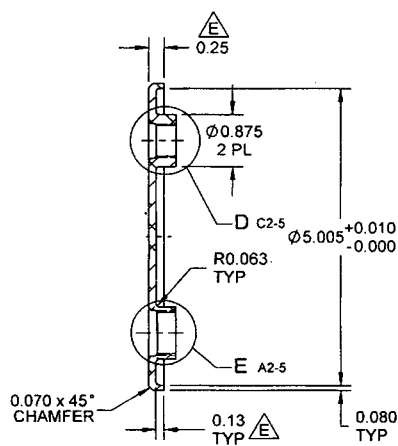
**DETAIL B** C7-4  
SCALE 2X

**NOTES:**

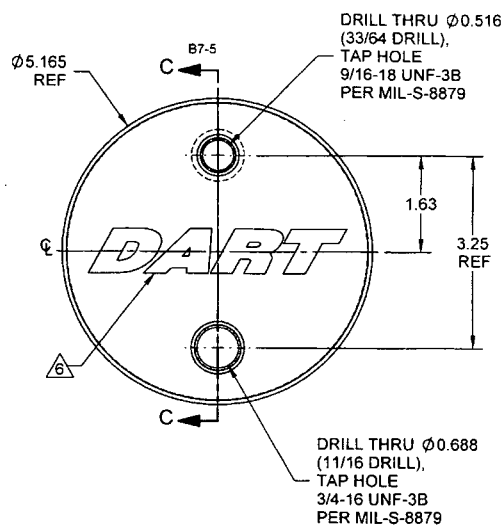
- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR  
PER QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP  
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.28 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

**RELEASED**  
2010-05-07  
AN

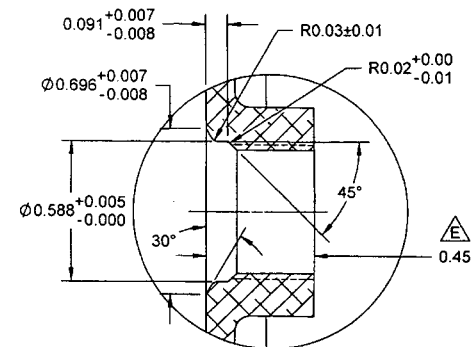
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3262	SHEET 4 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FUEL PURGE CANISTER	NTS
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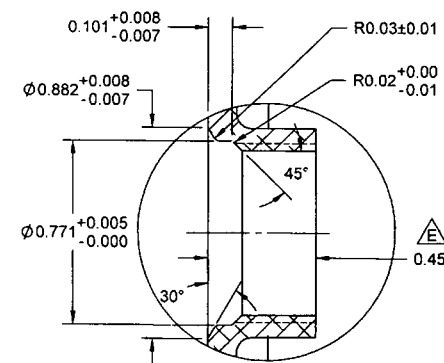
**SECTION C-C** D5-5



**D3262-5 CAP**



**DETAIL D** C7-5  
SCALE 2X



**DETAIL E** B7-5  
SCALE 2X

**RELEASED**  
2010-05-07  
JW

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR  
PER QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP  
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.27 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3262	SHEET 5 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FUEL PURGE CANISTER	NTS
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